

Date: Wednesday, 20/09/2006 2:03:45 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOP PLATE
Job Number : 28628	
Estimate Number : 11211	
P.O. Number : N/A	Part Number : D33309
This Issue : 20/09/2006 S.O. No. : N/A	Drawing Number : D3330 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B1
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 30/09/2006 Qty: 6 Um: Each
Checked & Approved By : _____	
Comment : Est: A 05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1010B0375X03500	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.2888 f(s)/Unit Total : 1.7325 f(s)

1010-1025 Steel Bar

Fabricate Top Plate as per Dwg D3330

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 0.375" x 3.500" Ba
 (M1010-B0.375x03.500)

Identify as D3330-9

Batch: M102179

Cpl 06.09.25.

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Cpl 06.09.25

Comment: LARGE FABRICATION RESOURCE 1

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



06.09.25 (6)

Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



06.09.25 6

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



(6)

Comment: FINAL INSPECTION/W/O RELEASE

06/09/26

Job Completion



u 06.09.26

Date: Friday, 9/15/2006 12:04:48 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TOP PLATE
Job Number :	28628	Part Number :	D33309
Estimate Number :	11211	Drawing Number :	D3330 REV B1
P.O. Number :		Project Number :	N/A
This Issue :	9/15/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	B1
First Issue :	//	Material :	
Previous Run :		Due Date :	9/30/2006
Written By :		Qty:	6 Um: Each
Checked & Approved By :	06 09 15		
Comment :	Est: A 05.01.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010B0375X03500

1010-1025 Steel Bar



Comment: Qty.: 0.2888 f(s)/Unit Total : 1.7325 f(s)

1010-1025 Steel Bar

Fabricate Top Plate as per Dwg D3330

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 0.375" x 3.500" Ba

(M1010-B0.375x03.500)

Identify as D3330-9

Batch: _____

2.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

4.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

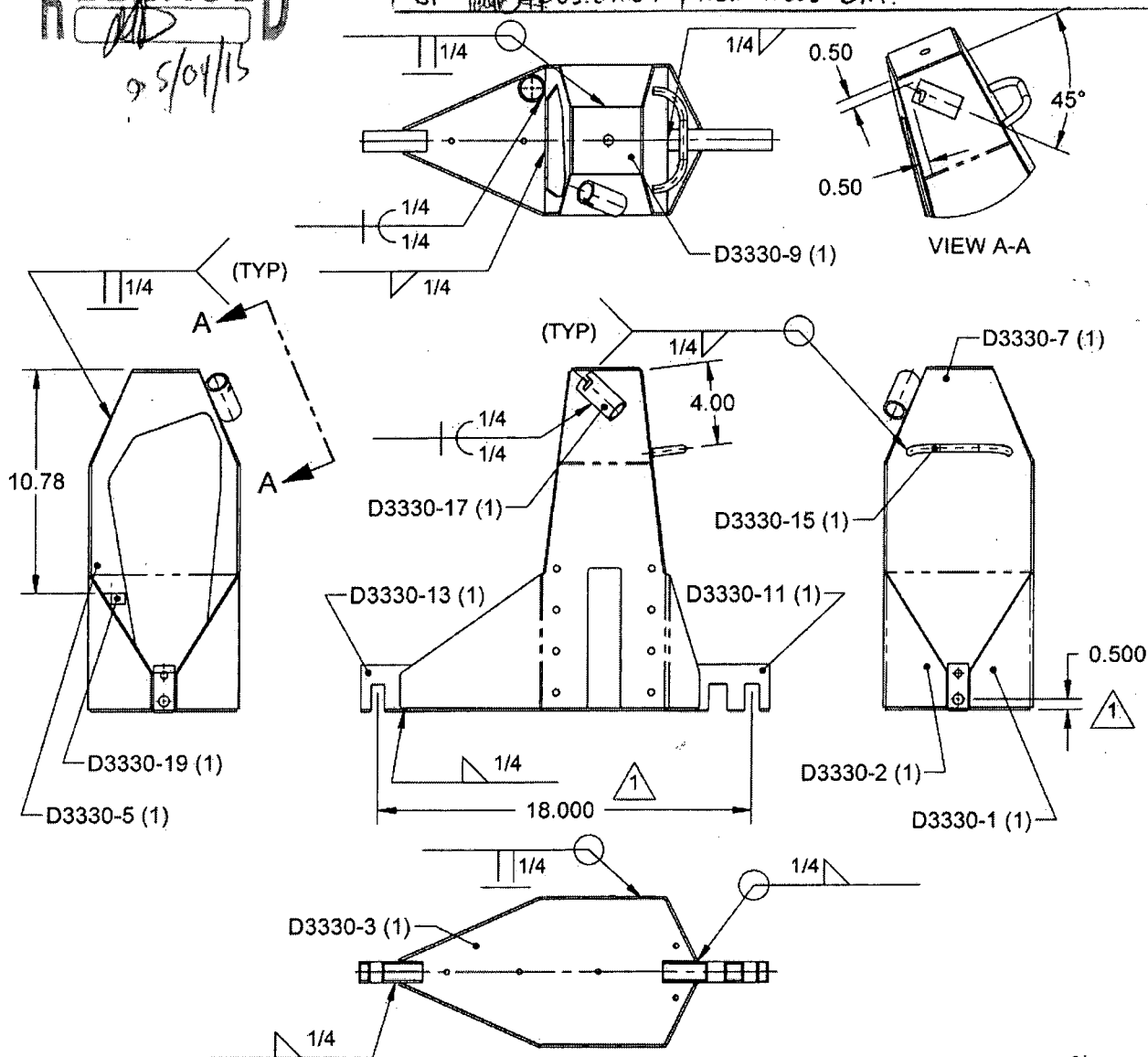
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	
BI	05.07.04	ADD 1.605 DIM.	

RELEASED
[Signature]
9/5/04/15**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

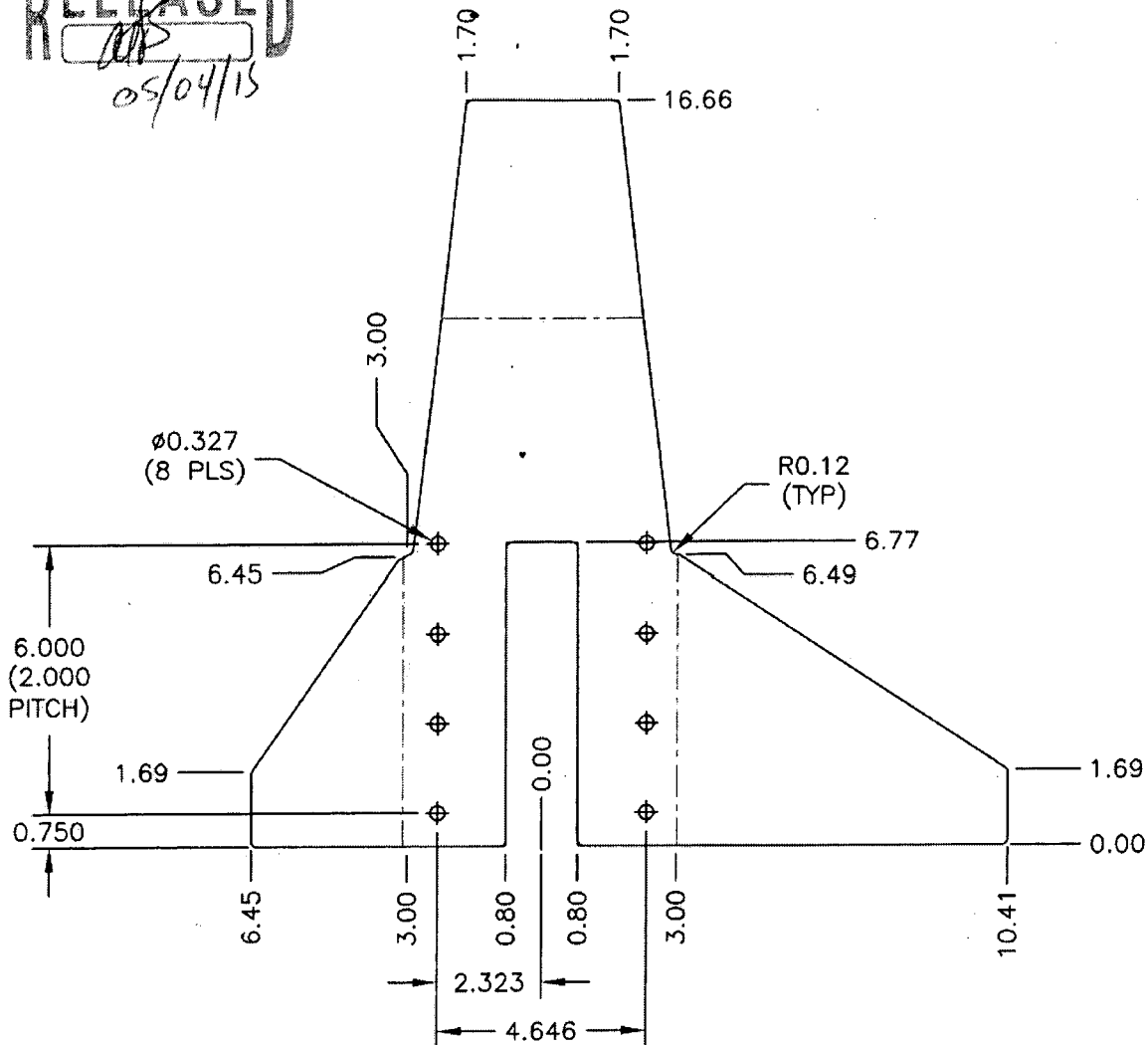
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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05/04/15**D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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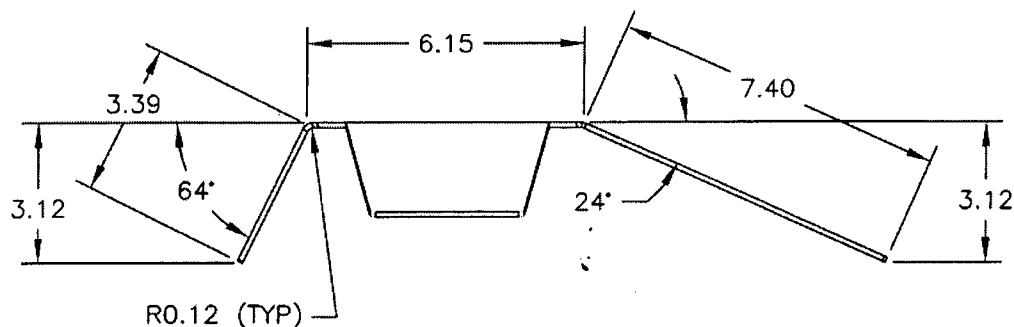
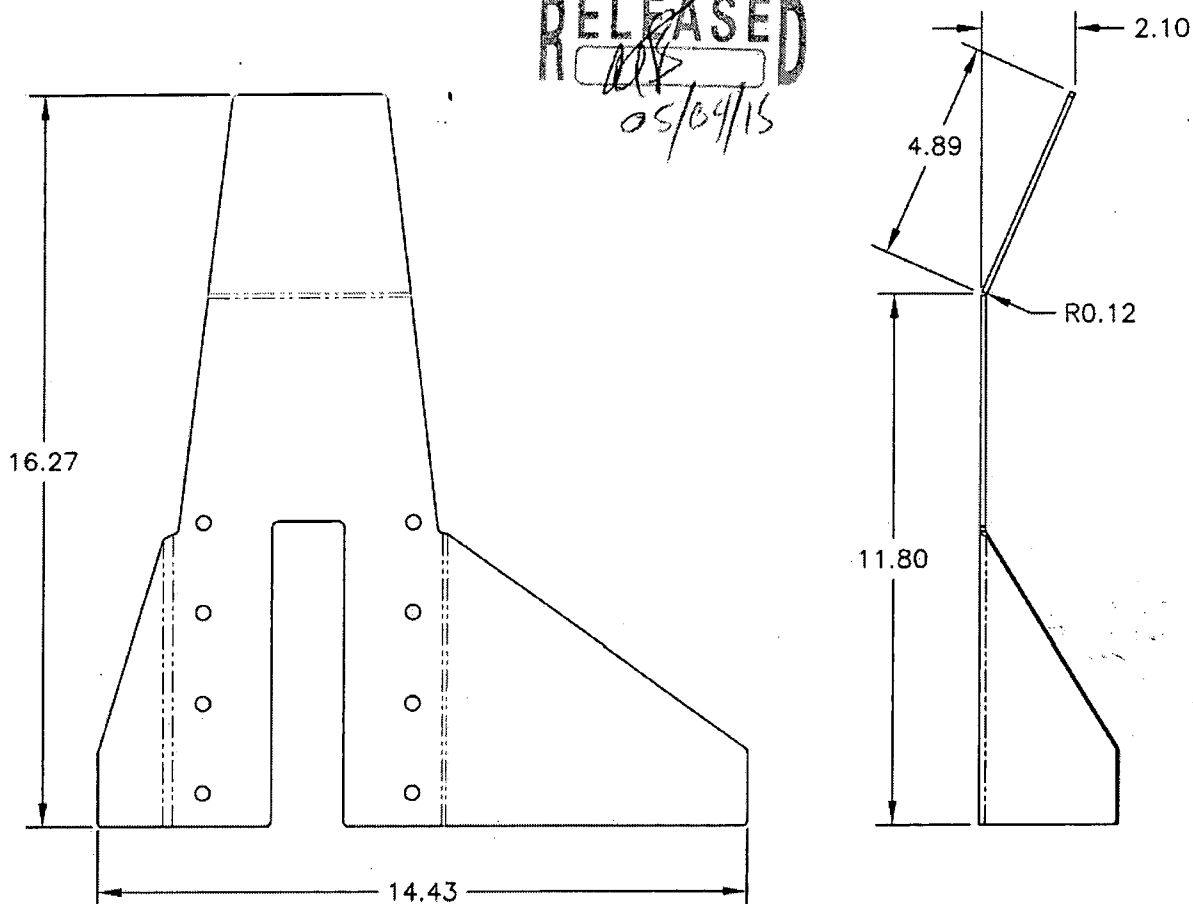
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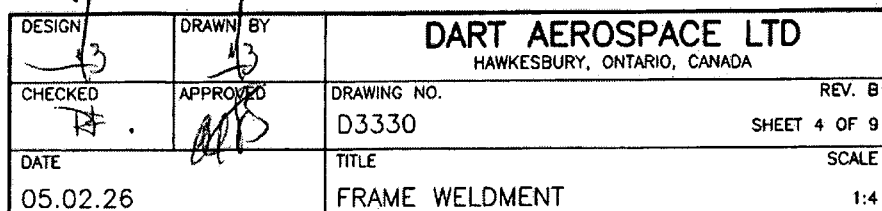


D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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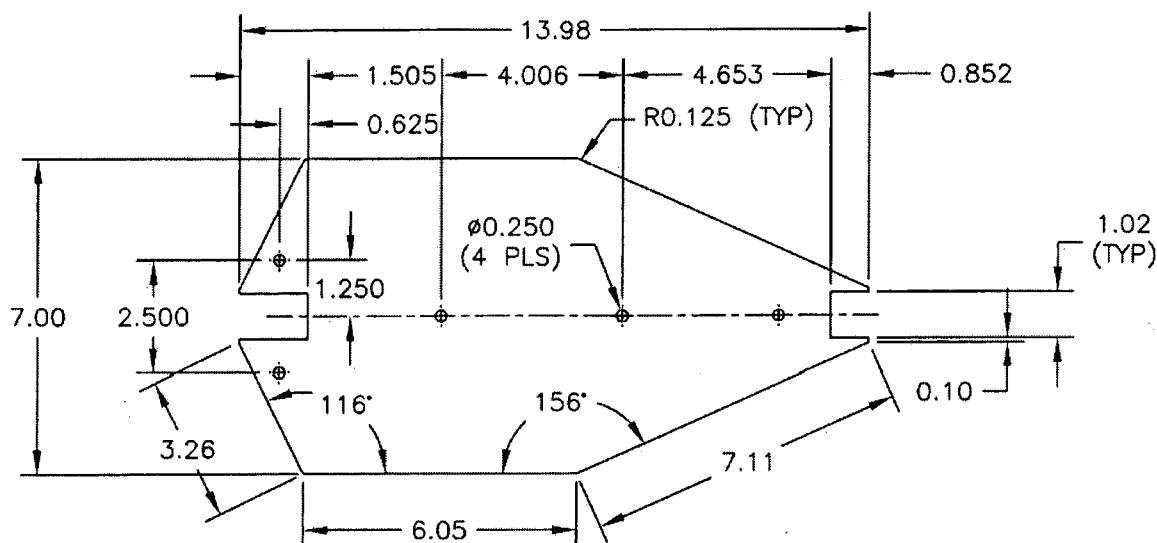
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05/04/15



D3330-3 PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.119)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

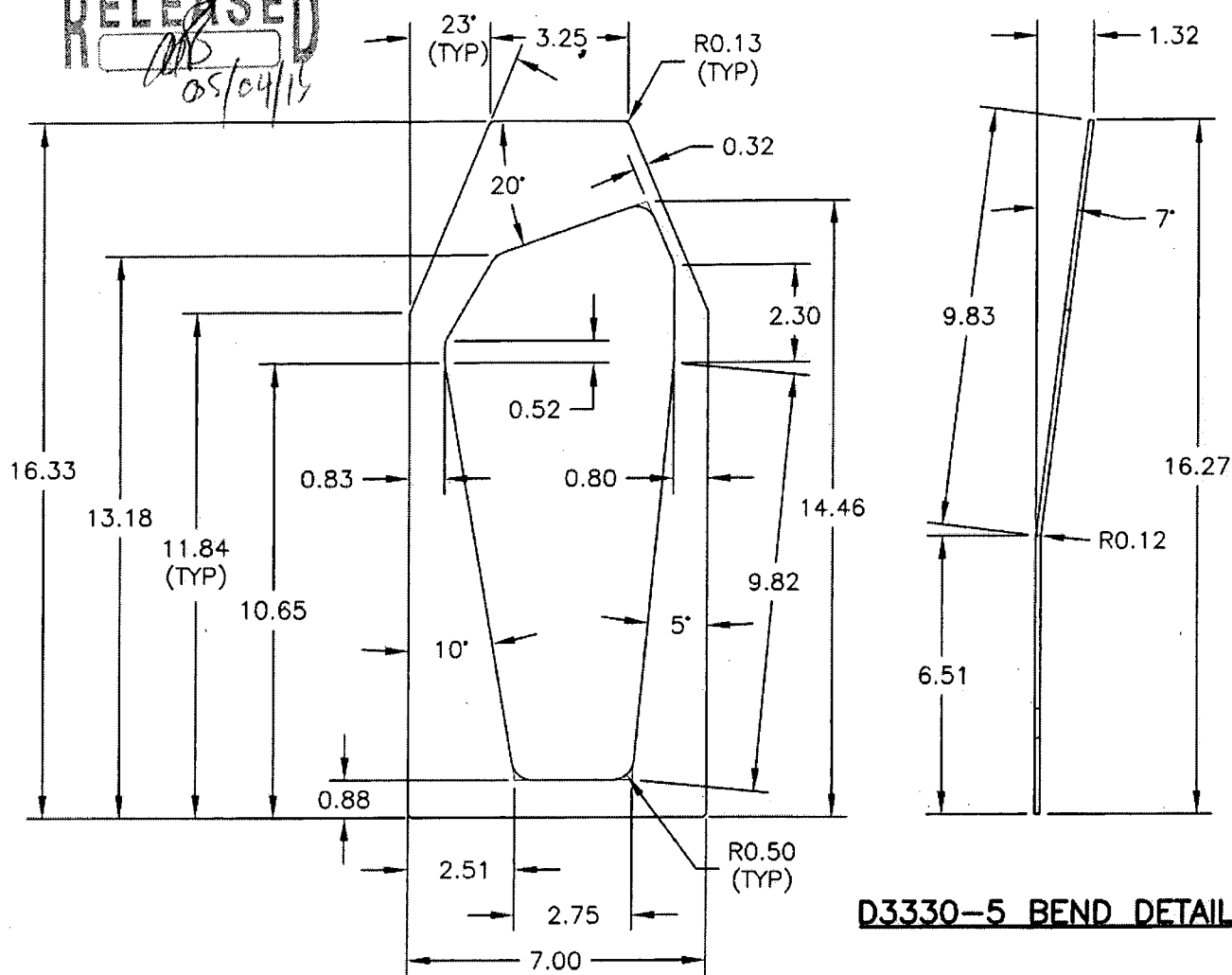
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:4



FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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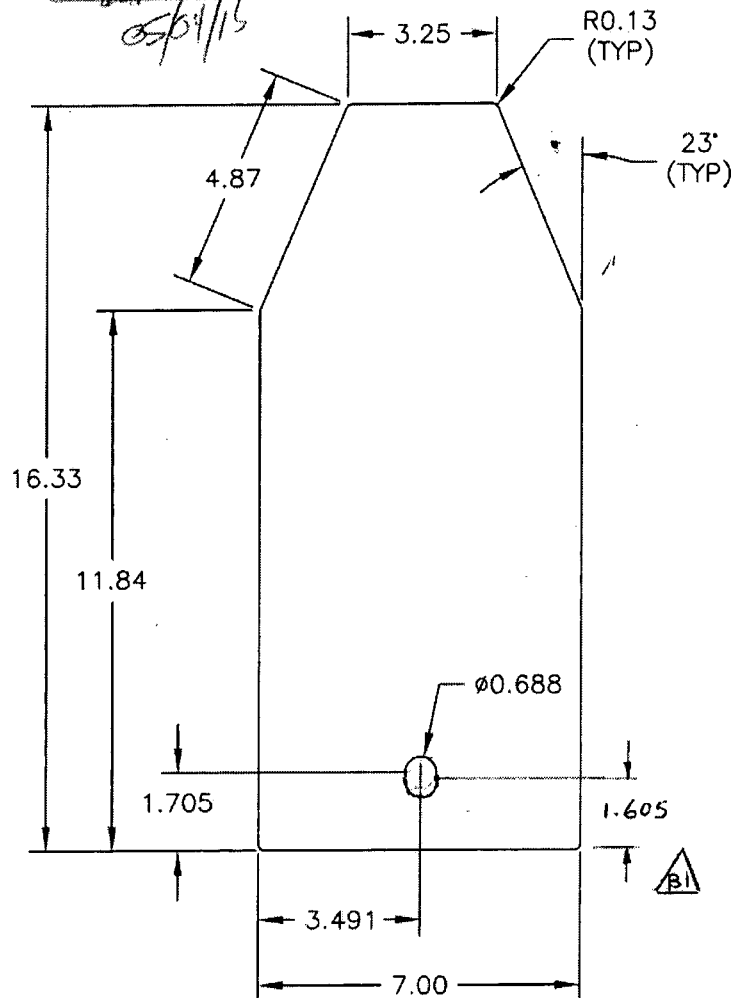
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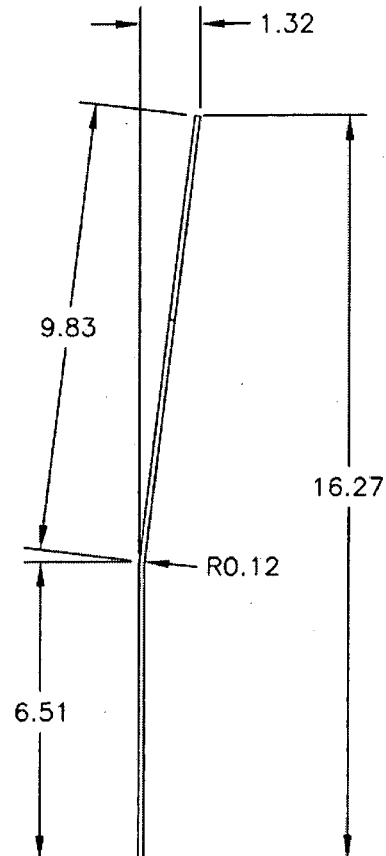


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DATE 05.02.26		TITLE FRAME ASSEMBLY	SCALE 1:4

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05/04/15



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

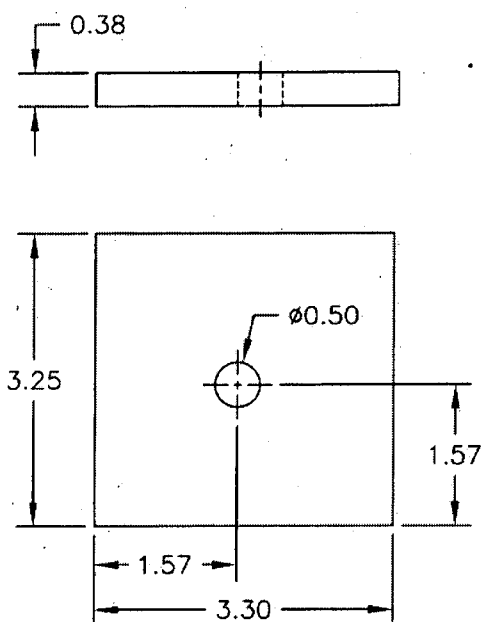
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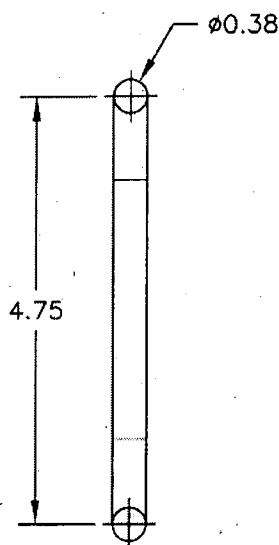
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:2



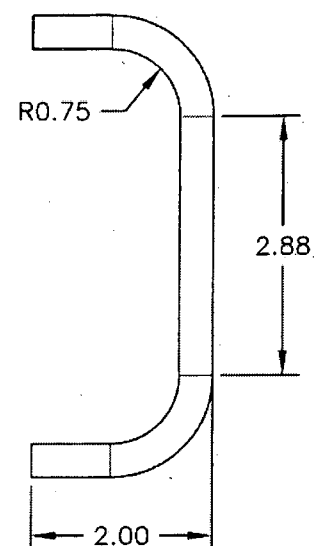
△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

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05/04/15



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

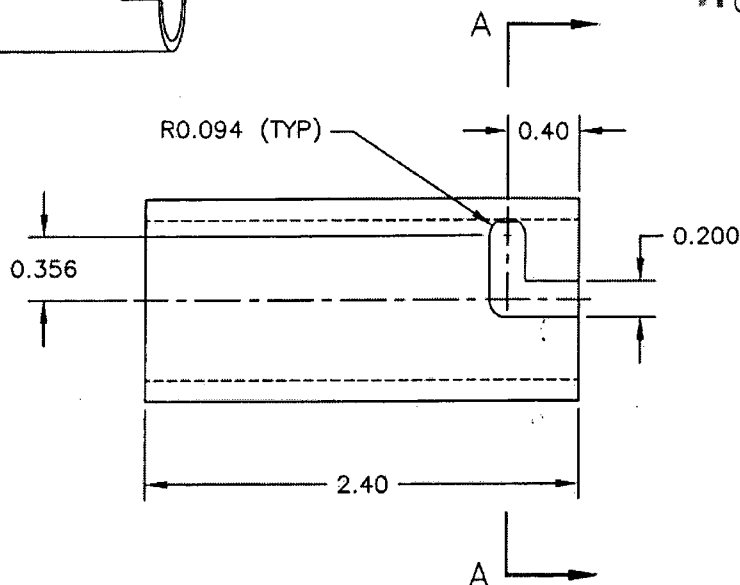
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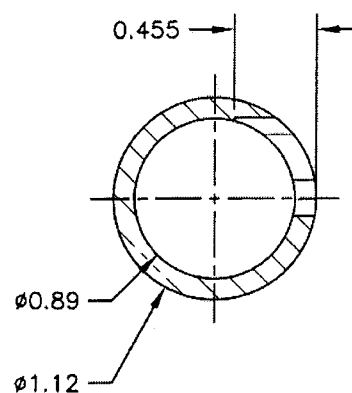
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1

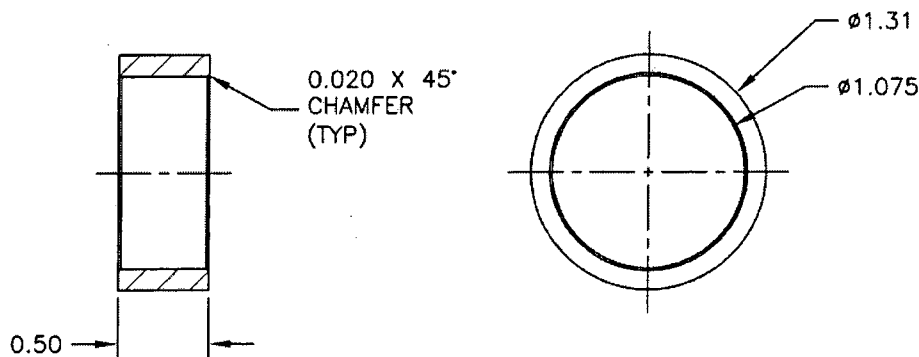


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05/04/15



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

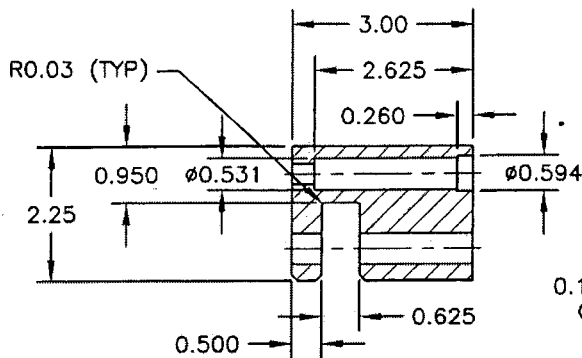
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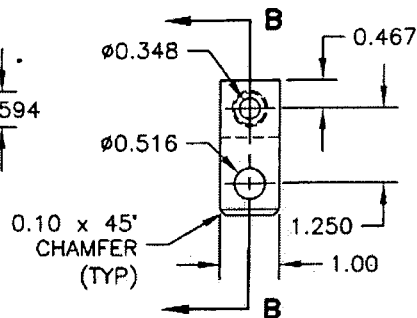


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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3

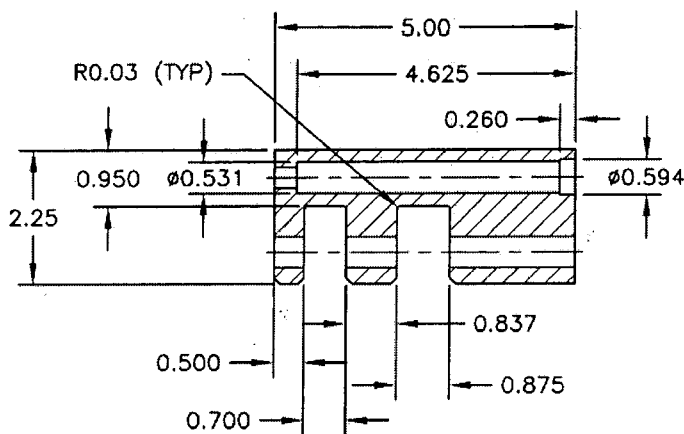
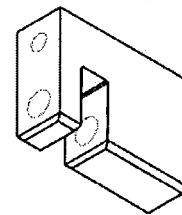


SECTION B-B

D3330-13 SHORT PIN BRACKET

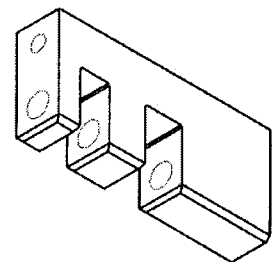
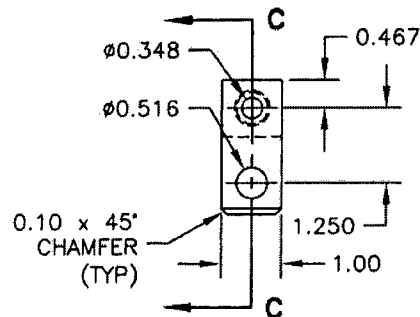


RELEASED
05/04/15.



SECTION C-C

D3330-11 LONG PIN BRACKET



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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